

Date: Friday, 30/05/2008 10:12:48 AM  
 User: Julie Lecocq

## Process Sheet

|                                    |                                     |                           |               |
|------------------------------------|-------------------------------------|---------------------------|---------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b> :     | X-BOLT SPACER |
| <b>Job Number</b> :                | 39600                               |                           |               |
| <b>Estimate Number</b> :           | 12321                               |                           |               |
| <b>P.O. Number</b> :               |                                     | <b>Part Number</b> :      | D34901        |
| <b>This Issue</b> :                | 30/05/2008                          | <b>S.O. No.</b> :         |               |
| <b>Prsht Rev.</b> :                | NC                                  | <b>Drawing Number</b> :   | D3490 REV A   |
| <b>First Issue</b> :               | / /                                 | <b>Project Number</b> :   | N/A           |
| <b>Previous Run</b> :              | 39584                               | <b>Drawing Revision</b> : | A             |
| <b>Written By</b> :                |                                     | <b>Material</b> :         |               |
| <b>Checked &amp; Approved By</b> : | JUL 08.5.30                         | <b>Due Date</b> :         | 10/06/2008    |
| <b>Comment</b> :                   | Est Rev:A New Issue 06-03-03 JLM    | <b>Qty:</b>               | 60 Um: Each   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |                  |                          |
|-----|------------------|--------------------------|
| 1.0 | M6061T6T0500W049 | 6061-T6 Tube .500 x.049W |
|-----|------------------|--------------------------|



**Comment:** Qty.: 0.2793 f(s)/Unit Total : 16.7580 f(s)

6061-T6 Tube .500 x.049W

(M6061T6T0.500W.049)

Batch: M107515

J.F. 08/06/02 (64)

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



**Comment:** HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA628 & DWG D3490

FOLIO REV: AA

DWG REV: A

2-DEBURR AS REQUIRED

J.F. 08/06/02 (64)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/06/02 (64)

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

AA 08/6/05 (64)

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8/6/5

(64x)

SL

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:12:48 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 39600

Part Number: D34901

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(64)

Comment: FINAL INSPECTION/W/O RELEASE

7/08/06/06

Job Completion



64 08-06-06

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

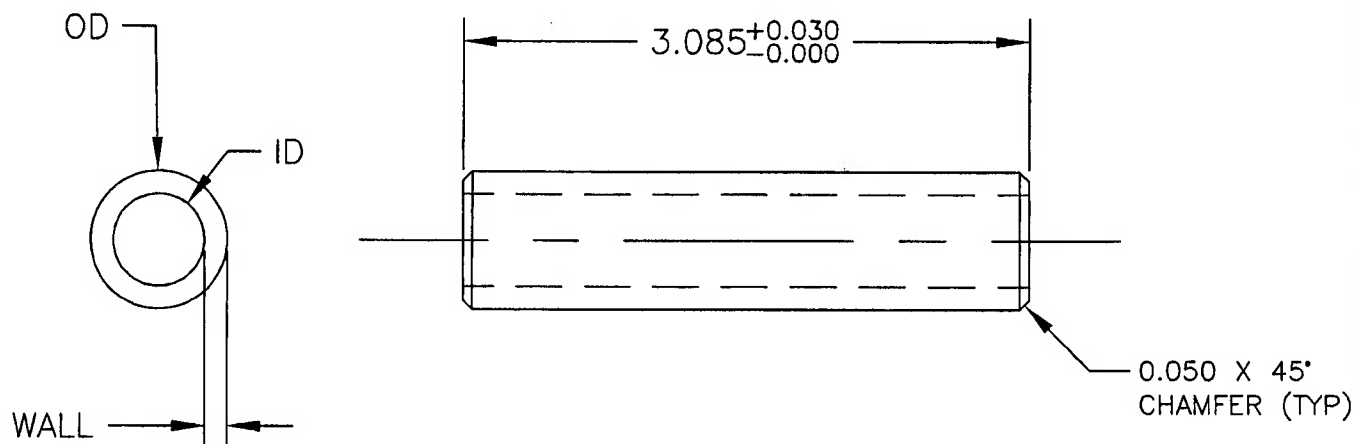
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>PH</i>           | DRAWN BY<br><i>PH</i>          | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3490                                | REV. A<br>SHEET 1 OF 1 |
| DATE<br>06.01.04              |                                | TITLE<br>CROSS BOLT SPACER                          | SCALE<br>NTS           |
| A                             | 06.01.04                       | NEW ISSUE   |                        |

**D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST**

| PART NUMBER | OD    | WALL  | ID (REF) | MATERIAL SPEC      |
|-------------|-------|-------|----------|--------------------|
| D3490-1     | 0.500 | 0.049 | 0.402    | M6061T6T0.500W.049 |
| D3490-3     | 0.750 | 0.080 | 0.591    | M6061T6R0.750      |
| D3490-5     | 0.313 | 0.058 | 0.197    | M6061T6T0.313W.058 |

**D3490-1/-3/-5 CROSS BOLT SPACER**

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 39600

**RELEASED**  
06-02-07

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